

Work Order ID 72557

Friday, July 29, 2011 9:00:23 AM



Page 1

Item ID: D3916-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Rib

Start Date: 7/29/2011 Start Qty: 9.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 9.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *H*

Date: *11-07-29*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3916

A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube 50"
2- Bend tube with manuel pipe bender as per DT9566
*** Make line at 9.00" annd use jig for other line***
3- Trim access tube material to finish size as per dwg D3916

SAD 11-08-11



110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

SAD 11-08-12



120

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

Packaging

SAD 11-08-13



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/15

ME
11-08-15

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, July 29, 2011 9:00:29 AM

Page 1

Work Order ID: 72557

Parent Item: D3916-5

Parent Item Name: Light Rib



Start Date: 7/29/2011


Required Date: 8/5/2011

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
as per dwg revA 10.03.15 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049  Square Tubing		Purchased	No			100	f	1,162.132	4.166	39.46737			



SAD

11-08-11

Location

Loc Qty

Loc Code

MAT034

1162.1324

116610

0.8383

117721

0.3234

117999

576.9707

118460

584

39.4674
~~39.4674~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

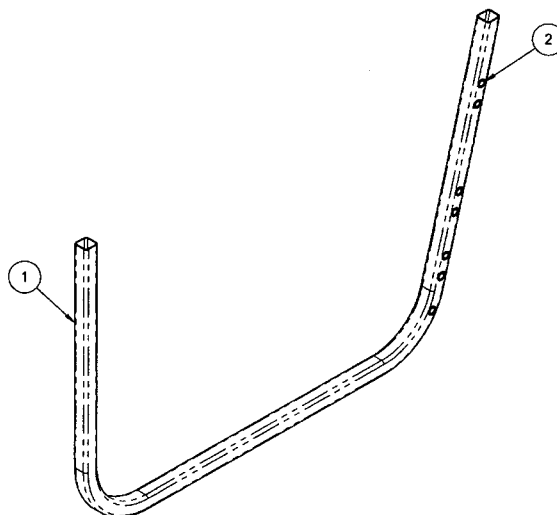
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

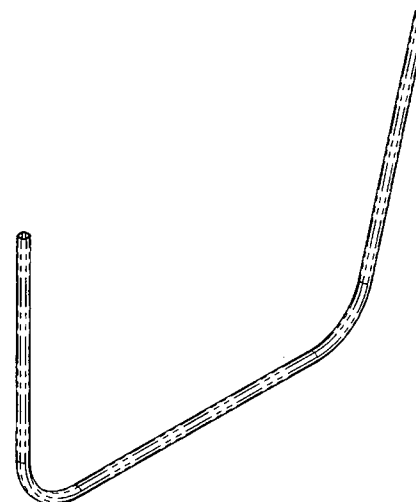
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72557

11-07-29

OK 10.12.21

UNDER REVIEW

ADDITION OF HOLE + BUSHING
on D3916-041-1 RIBS.

RELEASED

2010-03-12

JWP

A		NEW ISSUE		JPH		10.03.04	
REV.		DESCRIPTION		BY		DATE	
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				REV. A	
DRAWN	JPH					SHEET 1 OF 4	
CHECKED	<u>[Signature]</u>	DRAWING NO.					
MFG. APPR.	<u>[Signature]</u>	D3916					
APPROVED	<u>[Signature]</u>	TITLE				SCALE	
DE APPR.	<u>[Signature]</u>	RIB ASSY, 350 BASKET				NTS	
DATE		10.03.04					

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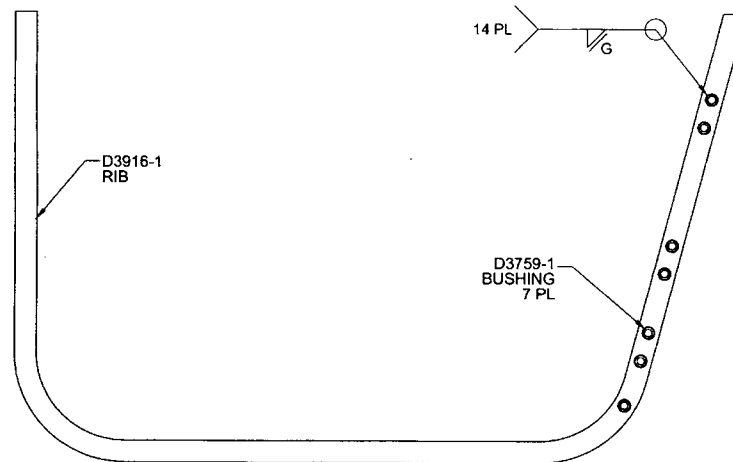
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NOTE: Date & initial all entries



D3916-041 RIB ASSY

12557

RELEASED
2010-03-12
AP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916	REV. A SHEET 2 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	10.03.04		

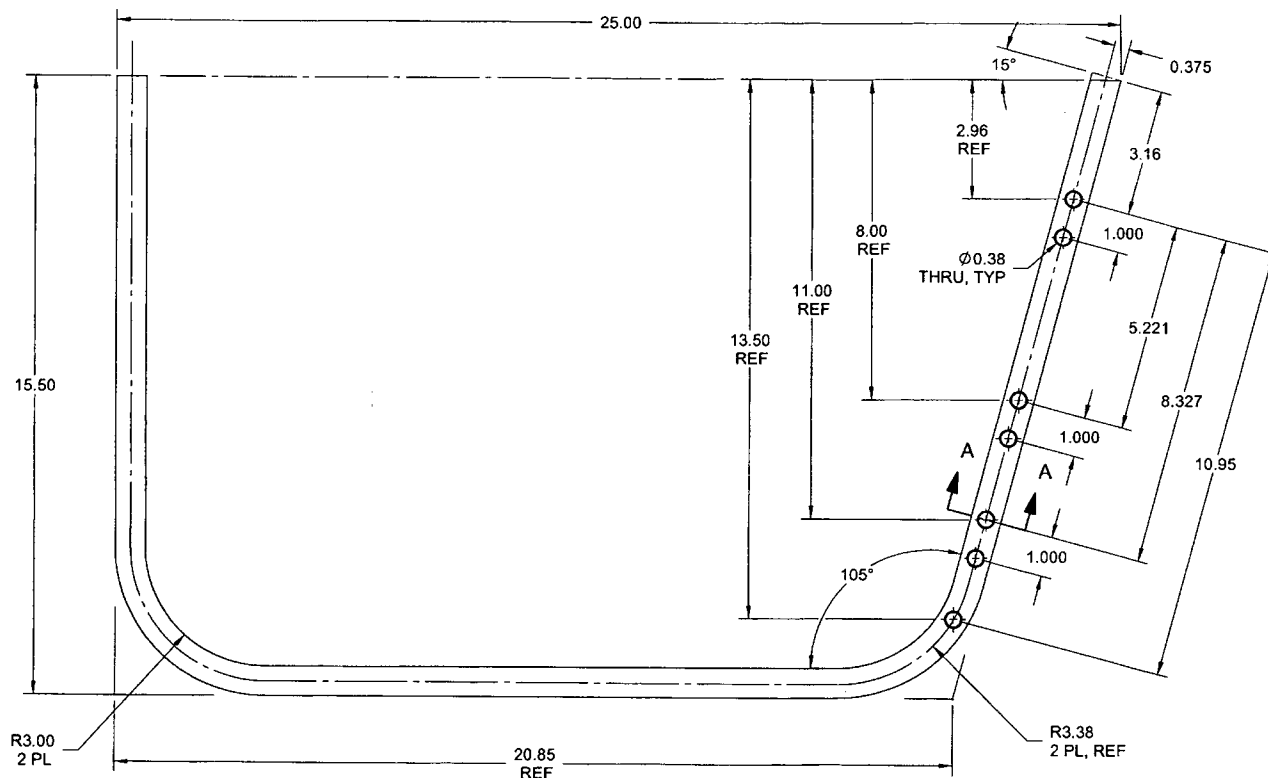
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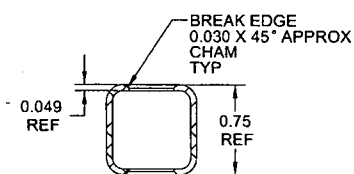
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NOTE: Date & initial all entries



72557



SECTION A-A

9 D3916-1 RIB

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

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DRAWN	JPH		
CHECKED	QD	DRAWING NO. D3916	REV. A
MFG. APPR.	E	SHEET 3 OF 4	
APPROVED	AW	TITLE RIB ASSY, 350 BASKET	SCALE NTS
DE APPR.	AW	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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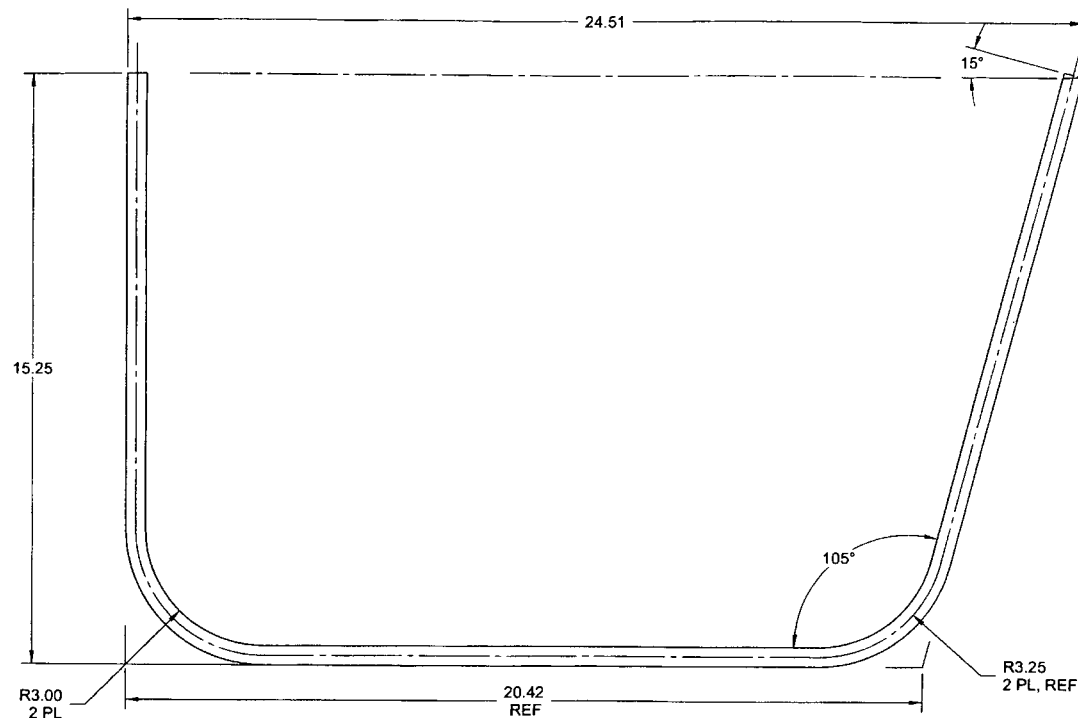
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NOTE: Date & initial all entries



72557

9 D3916-5 LIGHT RIB

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 4 OF 4
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